



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3884-2
Job Sheet 192327



Part No: D3884-2

Job Qty: 8 pcs

DAG

21

9-05

Part Name: Saddle, Inside RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/21/19

Job Tracking No:

Due Date: 4/8/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP RevA: New issue DD verified by:EC IPP REV:B 15.05.20 remove inside powdercoat DD
VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 5 Axis	8	4/8/19	4/8/19	0.00	14.04	HAAS 5		SBL/VMS 19/4/13
	HAAS 3	pcs					HAAS-3		
110	QC 2	8	4/8/19	4/8/19	0.00	0.00	QC 2 - 1		VMS 19/4/13
		pcs					QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		



Dart Aerospace Ltd.
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CANADA
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Container No: S168237



Part: D3884-2

Job No: 192327

Serial No/Batch: S168237

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/01/19

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120 QC 8	8 pcs	4/8/19	0.00	0.00	QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	mm L 19/04/17
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
130 Handfinish - 1-1 Chemical-B4B	8 pcs	4/8/19	0.00	0.75	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	D.R 19/04/17
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 -	

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170 QC 21 - SA		8 pcs	4/8/19	0.00	0.00	Packaging 3 - 36 - B4B	
						QC 21 - SA - 21	
						QC 21 - SA - 70	DAG
						QC 21 - SA - 53	21 APR 26 2019
Part Op 100 - HAAS CNC Vertical Machine - Program Batch No. _____ 1-Machine Step No 1 per Folio FA819 and inspect per Descriptions: attached Dimension Sheets 2-Machine Step No 2 per Folio FA819 and inspect per attached Dimension Sheets Step No 3 per Folio FA819 and inspect per Dimension Sheets 110 - QC2- Inspect parts off machine FAI/FAIB 120 - QC8- Inspect parts - second check 130 - Chemical Conversion Coat per QSI005 4.1 140 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum ***MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT AS PER INDICATED ON DWG (SEE NOTE 2)*** 150 - QC3- Inspect Part Finish 160 - Identify as per dwg & Stock Location: _____ 170 - QC21- Final Inspection - Work Order Release							
Job BOM							
Part / Item	Component Name	Quantity	Operation	Container			
D6101-017	Saddle Billet	8 pcs (1 ea)	100-HAAS 5 Axis	S134206			
Job Allocations							
Operation	Component Part	Required	Inventory	Allocated			
100-HAAS 5 Axis	D6101-017	8	27	0			
Part Specifications							
Specifications could not be found.							

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DART AEROSPACE LTD		Work Order:	192327
Description: Saddle, Inboard, RH		Part Number:	D3884-2
Inspection Dwg: D3884	Rev. C	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		0.646	0.646	0.646	0.646		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		0.257	0.257	0.257	0.257		
F	0.605	0.625		0.612	0.614	0.616	0.617		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.005	2.005	2.005	2.005		
J	0.140	0.175		0.150	0.151	0.151	0.151		
K	1.265	1.285		1.270	1.270	1.270	1.270		
L	0.115	0.135		0.123	0.123	0.122	0.122		
M	0.240	0.260		0.250	0.248	0.247	0.247		
N	0.110	0.140		0.135	0.135	0.135	0.135		
O	0.240	0.260		0.250	0.250	0.250	0.250		
P	2.826	2.886		2.856	2.856	2.856	2.856		
Q	0.178	0.198		0.188	0.188	0.188	0.188		
R	0.140	0.165		0.148	0.150	0.150	0.150		
S	0.720	0.780		0.745	0.745	0.745	0.745		
T	1.220	1.280		1.250	1.250	1.250	1.250		
U	1.245	1.255		1.250	1.250	1.250	1.250		
V	5.990	6.010		6.000	5.999	6.000	6.000		
W	2.495	2.505		2.500	2.500	2.500	2.500		
X	0.490	0.510		0.502	0.499	0.499	0.4973		
Y	0.020	0.040		0.035	0.035	0.035	0.035		
Z	0.313	0.318		0.313	0.313	0.313	0.313		
AA	0.760	0.765		0.761	0.761	0.761	0.761		
AB	0.215	0.220		0.220	0.219	0.219	0.219		
AC	0.316	0.321		0.316	0.316	0.316	0.316		
AD	1.745	1.755		1.750	1.750	1.750	1.750		
AE	0.990	1.010		1.000	1.000	1.000	1.000		
AF									
Accept/Reject									

Measured by:	19/04/12	Audited by:	19/04/12
Date:		Date:	

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	
B	15.09.09	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order:	192327
Description: Saddle, Inboard, RH		Part Number:	D3884-2
Inspection Dwg: D3884 Rev. C		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	15	16	17	18		
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		0.648	0.647	0.647	0.647		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		0.257	0.257	0.257	0.257		
F	0.605	0.625		0.616	0.617	0.617	0.619		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.005	2.005	2.005	2.005		
J	0.140	0.175		0.150	0.150	0.149	0.150		
K	1.265	1.285		1.270	1.270	1.270	1.270		
L	0.115	0.135		0.122	0.123	0.123	0.122		
M	0.240	0.260		0.248	0.248	0.248	0.249		
N	0.110	0.140		0.135	0.135	0.135	0.135		
O	0.240	0.260		0.251	0.251	0.250	0.249		
P	2.826	2.886		2.856	2.856	2.856	2.856		
Q	0.178	0.198		0.188	0.188	0.188	0.188		
R	0.140	0.165		0.150	0.150	0.150	0.149		
S	0.720	0.780		0.745	0.745	0.745	0.745		
T	1.220	1.280		1.250	1.250	1.250	1.250		
U	1.245	1.255		1.250	1.250	1.250	1.250		
V	5.990	6.010		6.000	6.000	6.000	6.000		
W	2.495	2.505		2.500	2.500	2.500	2.500		
X	0.490	0.510		0.498	0.497	0.498	0.497		
Y	0.020	0.040		0.031	0.031	0.031	0.031		
Z	0.313	0.318		0.035	0.035	0.035	0.035		
AA	0.760	0.765		0.761	0.761	0.761	0.761		
AB	0.215	0.220		0.219	0.219	0.219	0.219		
AC	0.316	0.321		0.316	0.316	0.316	0.316		
AD	1.745	1.755		1.750	1.750	1.750	1.750		
AE	0.990	1.010		1.000	1.000	1.000	1.000		
AF									
Accept/Reject									

Measured by:		Audited by:	
Date:	19/04/02	Date:	19/04/17

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	
B	15.09.09	Dwg Rev updated	KJ	

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